

DT 8731



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2662-1

Job Sheet 200386



Part No: D2662-1

Job Qty: 4 pcs

Part Name: Saddle, LH Fwd, Aft, In



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/10/19

Job Tracking No:

Due Date: 10/8/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP: C 00.06.22 Removed P/O for powder coat EC IPP Rev:D As per Rev D 07-03-19 JLM IPP
REV:D REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	4 pcs	10/8/19		1.00	5.01	HAAS - 1		
							HAAS - 2		
							HAAS - 3		SBL 19/09/15
							HAAS - 4		
110	Conventional Mill - 1 - B4B	4 pcs	10/8/19		0.00	2.00	Conventional Mill - 1 - B4B		SBL 19/09/15
							Conventional Mill - 2 - B4B		
120	QC 2	4 pcs	10/8/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		



Container No: S213734



Part: D2662-1

Job No: 200386

Serial No/Batch: S213734

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 09/13/19

Plex 9/10/19 3:24 PM Dart.lajeunesse.marie

130 QC 8	4 pcs	10/8/19	0.00 0.00	QC 2 - 57	SB2 19/09/15
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
140 Handfinish - 1-1 Chemical-B4B	4 pcs	10/8/19	0.00 0.16	QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	PMML 6/8/17
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	★ SEP 20 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	

9/10/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

150 Powdercoat - 1 White GI(A)- B4B <i>M19B45A</i>	4 pcs	10/8/19	0.00 0.15	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	<i>BK 19-9-83</i>
				Powdercoat - 4 - B4B	
160 QC 3	4 pcs	10/8/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	DAS 28 9-89
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
170 Packaging 3-1 - Stock - B4B	4 pcs	10/8/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS 28 9-89
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
180 QC 21 - SA	4 pcs	10/8/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	SEP 25 2019 DAS 70 9-89
				QC 21 - SA - 53	

Part Op 100 - Program part number and batch number. Inspect part number and batch number are programmed MACHINE AS

Descriptions: PER FOLIO FB068 & DWG DWG REV: *E* FOLIO REV: *MA*

110 - (Manufacture as per dwg), Machine Keyway and inspect per attached dimension sheet

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

140 - Chemical Conversion Coat per QSI005 4.1

150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: _____ OVENTEMPERATURE: _____

FINISH TIME: _____

160 - QC3- Inspect Part Finish

170 - Identify as per dwg & Stock Location: _____

180 - QC21- Final Inspection - Work Order Release

Plex 9/10/19 3:24 PM Dart.lajeunesse.marie

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6101-001	Saddle Billet	4 pcs (1 ea)	100-HAAS 4 Axis	5204166
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-001	4	41	0
Part Specifications				
Specifications could not be found.				

Plex 9/10/19 3:24 PM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 200786
Description: 206 Saddle, Inboard, Left side		Part Number: D2662-1
Inspection Dwg: D2662	Rev: E	DSK: Rev: Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.614	3.615	3.615	3.615	
B	0.256	0.263		.257	.257	.257	.257	
C	0.315	0.322		.316	.316	.316	.316	
D	2.495	2.505		2.500	2.500	2.500	2.500	
E	1.674	1.684		1.679	1.679	1.679	1.679	
F	0.100	0.140		.120	.122	.121	.121	
G	0.210	0.230		.220	.222	.221	.220	
H	0.615	0.685		.680	.680	.680	.680	
I	2.470	2.510		2.495	2.495	2.495	2.495	
J	1.313	1.343		1.323	1.323	1.323	1.323	
K	0.178	0.198		.188	.188	.188	.188	
L	0.470	0.530		.500	.500	.500	.500	
M	1.125	1.145		1.135	1.135	1.135	1.135	
N	0.100	0.180		.138	.138	.138	.135	
O	0.100	0.140		.135	.137	.137	.135	
P	0.240	0.260		.251	.250	.251	.250	
Q	0.677	0.697		.689	.688	.688	.688	
R	0.540	0.560		.548	.549	.549	.549	
S	0.912	0.932		.922	.921	.921	.921	
T	0.787	0.807		.797	.797	.796	.797	
U	5.990	6.010		6.000	6.000	6.000	6.000	
V	4.995	5.005		5.000	5.000	5.000	5.000	
W	0.490	0.510		.500	.500	.500	.500	
X	0.312	0.319		.313	.313	.313	.313	
Y	0.990	1.010		1.000	1.001	1.000	1.000	
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	
AB	0.490	0.510		.500	.500	.500	.500	
AC	3.745	3.755		3.750	3.750	3.750	3.750	
AD	0.100	0.140		.140	.137	.138	.138	
AE	0.235	0.240		.239	.239	.239	.239	
AF	0.510	0.515		.510	.511	.511	.511	
AG	0.100	0.120		.115	.115	.115	.115	
AH	1.565	1.585		1.575	1.575	1.575	1.575	

DAS
57
9.89

Accept/Reject

Measured by: 9.89	Date: 19/08/15
Audited by: con ml	Date: 19/09/17
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	
H	12.03.08	Dimension AH added, O revised	KJ	M



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QSI042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced ☐
Bending ☐
Crushing ☐
Cracks ☐
Crimp/Kink/Ripple/Wave/Twist ☐
Marks/Chatter ☐
Mislabeled ☐
Other/Details: _____

Contamination ☐
Misaligned/off center ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Incomplete/Unclear Instructions ☐
Drill Holes ☐
Fit/Function ☐

Power Loss/Surge ☐
Folio/Program ☐
Grain Direction ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set/Set-up ☐

Positioned Wrong ☐
Outside Tolerance ☐
Drawing ☐
Finish ☐
Part Lost/Missing ☐
Misread ☐